

Work Order ID 100947

100947

Page 1

May-01-13 7:09:20 AM

Item ID: D350-689-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Dual High Back Seat, LH
 Start Date: 4/30/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/30/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML3 Date: 13-05-03 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9588	B
IIN-D350-689	B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-689-021 CHG005								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

13/10/7 ①

13/10/5 ①

32

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---

Work Order ID 100947

100947

Page 2

May-01-13 7:09:20 AM

Item ID: D350-689-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual High Back Seat, LH

Start Date: 4/30/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120			DAS	13/10/7					
QC	Memo	0.00	6						
Quality Control			9-89						
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-021								
	Location: 0-57A 060								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS 6 13/10/8

13-10-9

ME 13-10-07

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

May-01-13 7:09:20 AM

Page 1

Work Order ID: 100947

Parent Item: D350-689-021

Parent Item Name: Dual High Back Seat, LH

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-23 new issue DD verified by: LL 08.12.24 IPP Rev:B chg002 DD 10.02.12
verified by:JLM IPP Rev:C chg004 DD 11.09.28 verified by:JLM IPP
Rev:D 12.01.12 now @ CHG005 (ecn12-501) DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-689-023 Energy Attenuating Floor Provisions DAS 6 9-89		Manufactured	No			110	Each	3.0000	1	1	103009		DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG010		3							
				95896		2							
				99367		1							
D350-689-043 Dual High Back Seat Assembly DAS 6 9-89		Manufactured	No			110	Each	0.0000	1	1	107136		DAS 32 9-89
D3018-1 Seat Cushion DAS 6 9-89		Manufactured	No			110	Each	5.0000	1	1			DAS 32 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314A		1							
				95384		1							
				ST424		4							
				99332		4							
D3019-1 Seat Cushion DAS 6 9-89		Manufactured	No			110	Each	5.0000	1	1			DAS 32 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314A		1							
				95402		1							
				ST424		4							
				99356		4							

13/11/02 (1)

99356

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	---	--

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 1

REF. TCCA STC: SH02-33
REF. FAA STC: SR01620NY
REF. EASA STC: EASA.IM.R.S.01453
REF. TCA STC: 2005S03-09

1.0 PURPOSE

For D350-689-011/-013 at CHG 006/005 and later and D350-689-021/-023 Kits at CHG 005/004 and later, the D3026-1 Channel has been replaced with the D4575-1 Beam and D4575-3 Doubler and the D3234-3 Doubler has been removed. Consequently, the installation instructions for D350-689-011/-013 at CHG 006/005 and D350-689-021/-023 at CHG 005/004 are updated per Section 2.0 of this Service Instruction. The parts list update is shown in Section 4.0 of this Service Instruction. There is a negligible change to the weight and balance.

2.0 INSTALLATION CHANGES FOR D350-689-013

Section 3.9, *INSTALLATION OF D350-689-013 FLOOR PROVISIONS KIT* (pages 4 and 5 of IIN-D350-689), is changed as follows:

Item 3.3.15 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.3.15 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel & D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel & D3032-1 Spacer as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.3.17 is:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer to floor using MS20426AD4 rivets.

Item 3.3.17 was:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D3026-1 Channel and D3032-1 Spacer using MS20426AD4 rivets.

Item 3.3.22 is:

Rivet D3234-1 Doubler to D3025-1 Beam as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.3.25.

Item 3.3.22 was:

Rivet D3234-1 Doubler to D3025-1 Beam and D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.2.25.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

B	CHANGES TO -013 KIT INSTALLATION. REF: CIR12-12.	MB	12.11.09
A	NEW ISSUE	MB	11.12.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

100949 MCS
13-05-03

STANDARD
P. 100949
13-05-03

3.0 INSTALLATION CHANGES FOR D350-689-023

Section 3.9, *INSTALLATION OF D350-689-023 ENERGY ATTENUATING FLOOR PROVISIONS KIT* (pages 8 and 9 of IIN-D350-689), is changed as follows:

Item 3.9.8 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 2 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam and D4575-3 Doubler. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.9.8 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.9.10 is:

Attach D4575-1 Beam and D4575-3 Doubler to floor using qty (14) MS20426AD4 rivets.

Item 3.9.10 was:

Attach D4575-1 Channel to floor using qty (14) MS20426AD4 rivets.

Item 3.9.12 is no longer applicable:

~~Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.~~

Item 3.9.12 was:

Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

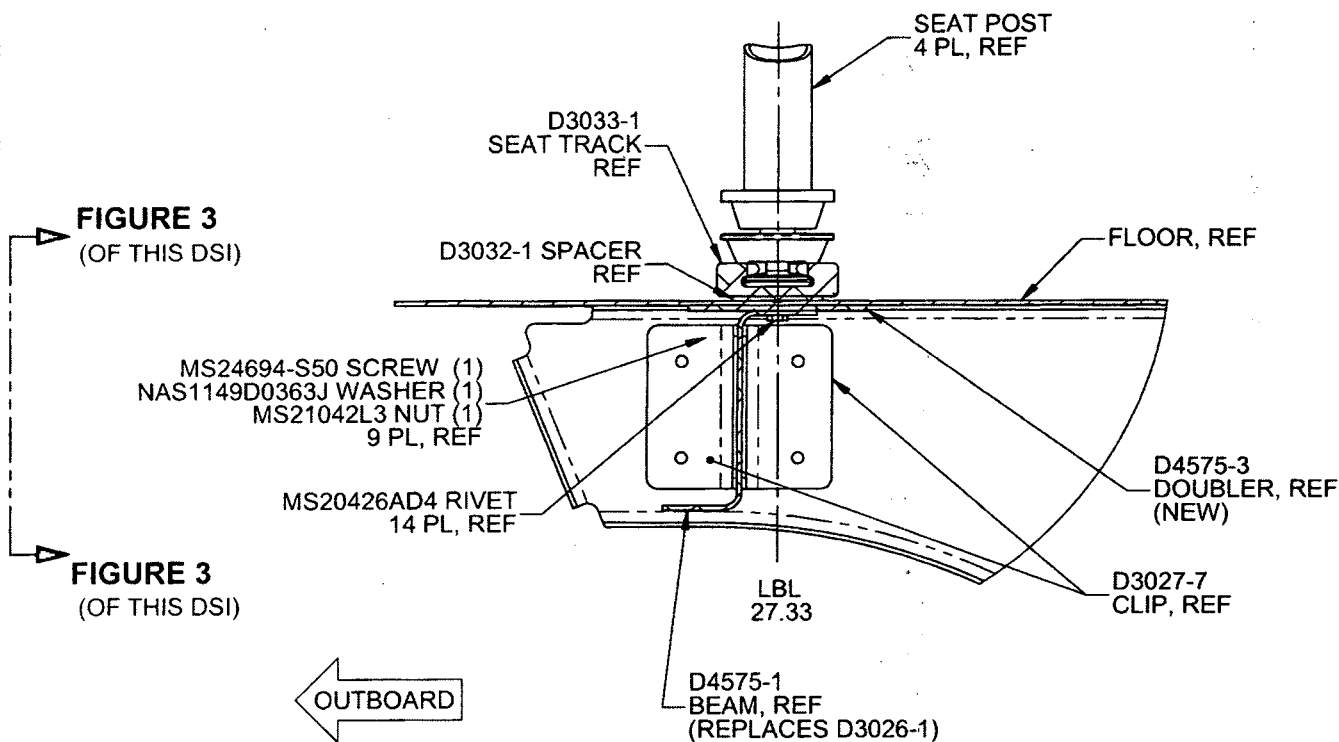
BY:

D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	B	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TH	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 2 OF 6
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

100947



CROSS SECTION VIEW F-F/M-M: From Figures 5 and 7 (IIN-D350-689)
CROSS SECTION VIEW F-F/M-M: From Figures 25-5 and 25-7 (ICA-D350-689)

FIGURE 1: UPDATES TO CROSS SECTIONS F-F AND M-M






With reference to Figures 5 and 7 of IIN-D350-689
 (Figures 25-5 and 25-7 of ICA-D350-689)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 12.11.09
 CERT. NO.: SH02-33
 ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

100947

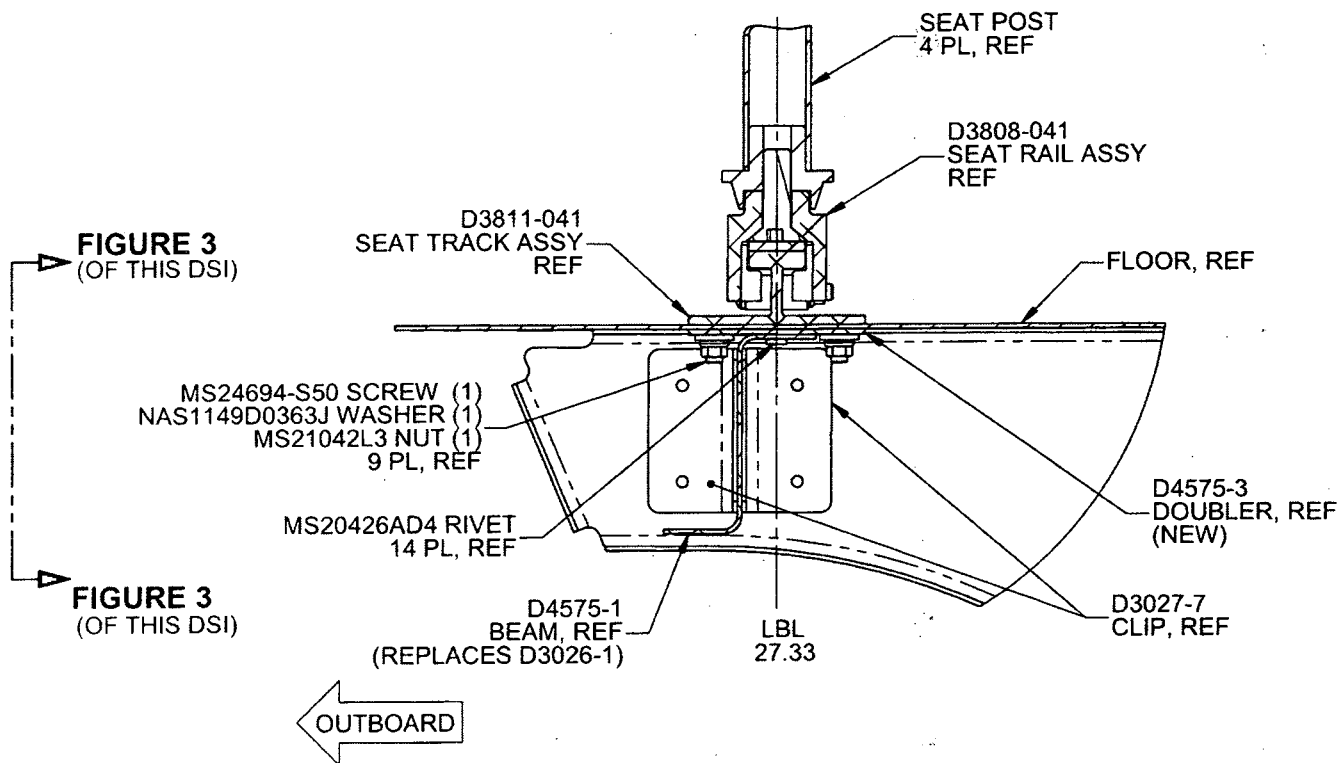


FIGURE 21: Cross Section View T-T from Figure 19 (IIN-D350-689)
FIGURE 25-21: Cross Section View T-T from Figure 25-19 (ICA-D350-689)

FIGURE 2: UPDATES TO FIGURE 21 (IIN-D350-689) AND 25-21 (ICA-D350-689)






With reference to Figures 19 and 20 of IIN-D350-689
 (Figures 25-19 and 25-20 of ICA-D350-689)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-Q-01

APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 12.11.09
 CERT. NO.: SH02-33
 ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

100947

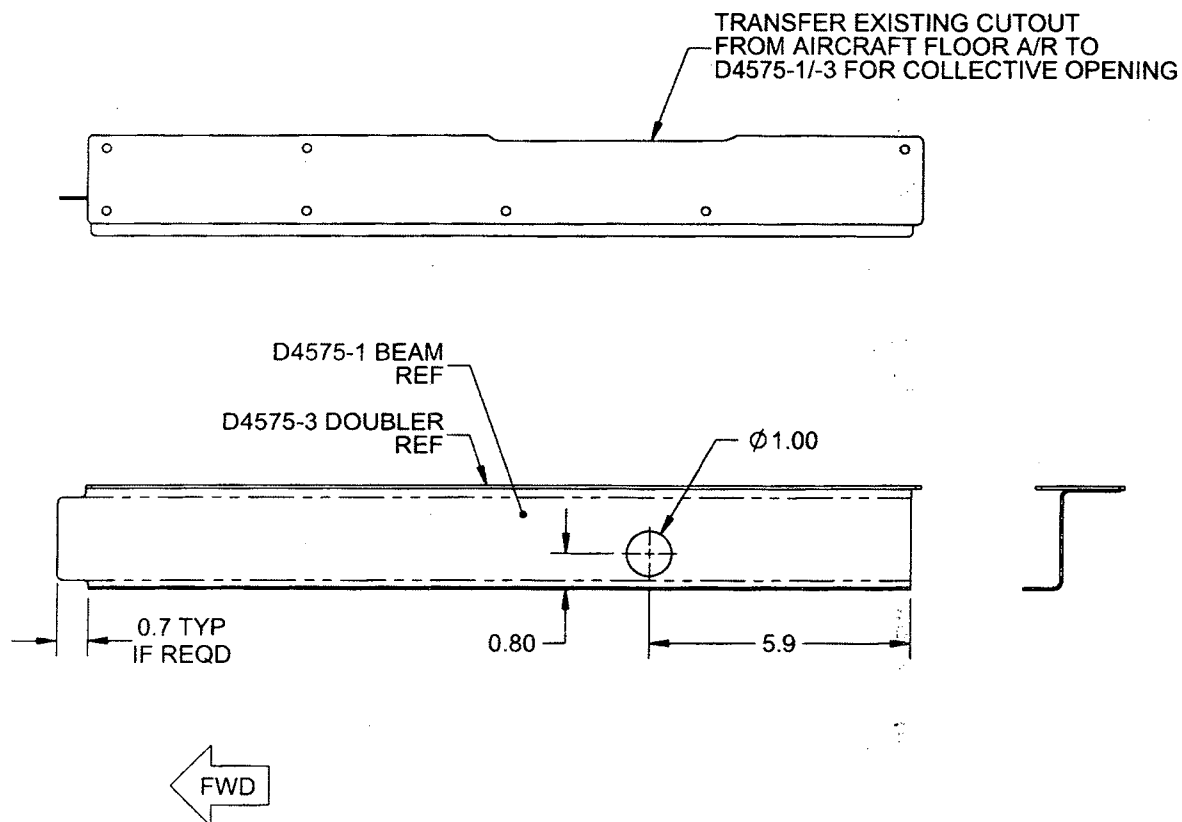


FIGURE 3: RELIEFS ON D4575-1/-3
(ONLY D4575-1/-3 SHOWN FOR CLARITY)
VIEW LOOKING INBOARD

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	B	
CHECKED	1	DRAWING NO. REV. B
MFG. APPR.	N/A	DSI 9588 SHEET 5 OF 6
APPROVED	1	TITLE SCALE
DE APPR.	1	INSTALLATION CHANGE NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

100547

4.0 PARTS LIST CHANGE

The parts list of D350-689-021/-023 at CHG 005/004 or later is amended as follows:

5. PARTS LIST (IIN-D350-689)
25.10 PARTS LIST (ICA-D350-689)

IS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
									D3026-1	CHANNEL (REMOVED)
									D3234-3	DOUBLER (REMOVED)
	1					1			D4575-1	BEAM (REPLACES D3026-1)
	1					1			D4575-3	DOUBLER (NEW)

WAS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
	1					1			D3026-1	CHANNEL
	1					1			D3234-3	DOUBLER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9588	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION CHANGE	NTS
DATE	12.11.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

100547

Work Order ID 100947

100947

May-01-13 7:09:20 AM

Item ID: D350-689-021

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Dual High Back Seat, LH

Start Date: 4/30/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/30/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: MLC Date: 13-05-03 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

DSI 9588	B
----------	---

IIN-D350-689	B
--------------	---

0.00

100

DOCUMENT CONTROL

100

0.00

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D350-689-021 CHG005

0.00

110

Pick Kit

110

0.00

Packaging

Memo

Packaging

MLC 13-10-07